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D5550-3

Job Sheet 203232



Part No: D5550-3

Job Qty: 4 pcs

Part Name: Aft Outboard Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/12/19

Description:

Note: DWG D5550 REV.A SHEETS 4,5 IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
105	Waterjet - Flow - 1	4 pcs	12/12/19		0.17	4.40	Waterjet - Flow		02/19/11/30
							Waterjet - Omax		
110	QC 2	4 pcs	12/12/19		0.00	0.00	QC 2 - 1		02/19/11/30
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120 HAAS 4 Axis - B4B	4 pcs	12/12/19	1.00	13.26	HAAS - 1 - B4B	
					HAAS - 2 - B4B	
					HAAS - 3 - B4B	
					HAAS - 4 - B4B	
130 QC 2	4 pcs	12/12/19	0.00	0.00	QC 2 - 1	mmL 19/12/14
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	mmL 19/12/14
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140 QC 8	4 pcs	12/12/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	mmL 19-12-17

						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
150	Handfinish - 1-1 Chemical-B4B	4 pcs	12/12/19	0.00	0.76	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	DEC 18 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
160	QC 7	4 pcs	12/12/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
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						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	<i>BA 19-12-18</i>
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
						QC 7 - 79	
						Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	<i>BA 19-12-18</i>
						Powdercoat - 4 - B4B	
170	Powdercoat - 1 White GI(A)- B4B	4 pcs	12/12/19	0.00	0.35	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	<i>DAS 40 9-89</i>
						QC 3 - 40	<i>JAN 06 2020</i>
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
180	QC 3	4 pcs	12/12/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	<i>DAS 28 9-89</i>
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
190	Packaging 3-1 - Stock - B4B	4 pcs	12/12/19	0.00	0.00		

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	8-32
				QC 21 - SA - 53	JAN 14 2020
200	QC 21 - SA	4	12/12/19	0.00 0.00	
		pcs			

ST421

Part Op 105 - ***GRAIN DIRECTION*** 1-Cut contour and pocket as per Dwg Dwg Rev: A Prog Rev: A 2-Debur if
 Descriptions: necessary

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (HAAS CNC Vertical Machine), Face and Drills holes as per dwg Dwg Rev: A

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - (Chemical Conversion Coat per QSI005 4.1)

11/13/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), ***Mask holes or blow out access powdercoat in holes*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	9.6000 ft (2.4 ea)	105-Waterjet - Flow - 1	S188587

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M6061T6B1.000X12.000	10	12	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	203232
Description: <u>Aft Outboard Beam</u>		Part Number:	D5550 3
Inspection Dwg: <u>D5550</u>	Rev: <u>A</u>	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.25	±0.01 +0.012	Ø 1.249	✓		V.D. 02	
1.00	±1-.030	.986	✓		Typical	
2.00	±1-.030	1.991	✓			
1.43	±1-.030	1.433	✓			
6.34	±1-.030	6.34	✓			
8.34	±1-.030	8.34	✓			
13.00	±1-.030	13.00	✓			
2.00	±1-.030	1.993	✓			
3.50	±1-.030	3.519	✓			
9.50	±1-.030	9.50	✓			
14.47	±1-.030	14.47	✓			
21.00	±1-.030	21.00	✓			
Ø 0.191	±0.006 -0.001	0.192	✓		Vern	mm-cs
0.600	±0.030	.595	✓			
0.750	±0.030	.748	✓			
3.000	±0.010	3.00	✓			
3.750	±0.010	3.750	✓			
1.506	±0.010	1.500	✓			
0.375	±0.010	.375	✓			
2.300	±0.010	2.306	✓			
1.150	±0.010	1.150	✓			
1.750	±0.030	1.750	✓			
Ø 0.377	±0.008 -0.001	0.378	✓			
0.600	±0.030	.599	✓			
0.630	±0.030	.624	✓			
3.600	±0.010	3.60	✓			
1.800	±0.010	1.800	✓			
2.300	±0.010	2.304	✓			

Measured by: <u>ac/aml</u>	Checked by: <u>De</u>	QC Inspector:
Date: <u>19/12/01</u> <u>14</u>	Date: <u>19-12-17</u>	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS																		
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐												
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																			
Description Work Order Deviation				Disposition																			
Completed By				Lead hand / Supervisor																			
QC / QA Coordinator																							
Root Cause												FAULT CATEGORY											
Operator ☐				Pressure/Forced ☐				Contamination ☐				Power Loss/Surge ☐											
Manufacturing Process ☐				Bending ☐				Misaligned/off center ☐				Folio/Program ☐											
Equip/Tooling ☐				Crushing ☐				BOM/Route ☐				Grain Direction ☐											
Handling/Preservation ☐				Cracks ☐				Broken/Damage/Defect ☐				Weld ☐											
Material ☐				Crimp/Kink/Ripple/Wave/Twist ☐				Incomplete/Unclear Instructions ☐				Wrong Stock Pulled ☐											
Product Improvement ☐				Marks/Chatter ☐				Drill Holes ☐				Out of Sequence ☐											
Process Improvement ☐				Mislabeled ☐				Fit/Function ☐				Off-set/Set-up ☐											
Human Factors ☐				Other/Details:								Positioned Wrong ☐											
												Outside Tolerance ☐											
												Drawing ☐											
												Finish ☐											
												Part Lost/Missing ☐											
												Misread ☐											